

Date: Wednesday, 3/7/2007 3:48:29 PM
 User: Kim Johnston

Process Sheet

| | |
|---|-------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : SKIDTUBE ASSEMBLY |
| Job Number : 31061 | |
| Estimate Number : 10022 | |
| P.O. Number : <u>N/A</u> | Part Number : D205634011 |
| This Issue : 3/7/2007 S.O. No. : <u>N/A</u> | Drawing Number : N/A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <u>NA</u> Type : LANDING GEAR | Drawing Revision : N/A |
| Previous Run : 31060 | Material : <u>N/A</u> |
| Written By : _____ | Due Date : 4/5/2007 Qty: 1 Um: Each |
| Checked & Approved By : <u>KS 07.03.07</u> | |
| Comment : Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG004

KS 07.03.23

| | | |
|-----|--------|--------------------|
| 2.0 | 31061A | SKID TUBE ASSEMBLY |
|-----|--------|--------------------|



Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 31061AS9

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

| | | |
|-----|--------|-------------------------|
| 4.0 | K10003 | D205-634-011 Saddle Kit |
|-----|--------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit 15307791 D205-634-041 Skidtube Assembly(ref) 1531061A3/4/1859

| | | |
|-----|-----|------------------------------------|
| 5.0 | QC4 | INSPECT 100% KITS FOR COMPLETENESS |
|-----|-----|------------------------------------|



Comment: INSPECT 100% KITS FOR COMPLETENESS

C207104/1803/4/18B31061A

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 01/04/15

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 3:48:29 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 31061

Part Number: D205634011

Job Number: 

Seq. #: Machine Or Operation: Description :

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: H

[Signature]

7/4/18 SG

7.0 QC21 FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

D207104/19

Job Completion



U 07-04-18

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Date: Wednesday, 3/7/2007 3:49:00 PM
 User: Kim Johnston

Process Sheet

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|-----------------------|--|------------------|----------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SKID TUBE ASSEMBLY |
| Job Number | : 31061A | | |
| Estimate Number | : 10023 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D205634041 |
| This Issue | : 3/7/2007 | Drawing Number | : D2580 REV C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> | Drawing Revision | : C |
| Previous Run | : 31060A | Material | : <i>N/A</i> |
| Written By | : | Due Date | : 4/5/2007 |
| Checked & Approved By | : <i>[Signature]</i> 07.03.07 | Qty: | 1 Um: Each |
| Comment | : Est Rev. N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ Est Rev. O 06.02.28 Added paperwork EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001

N/A

| | | |
|-----|-----------|------------------------|
| 2.0 | D25001190 | Ext'n -I' Beam Tube 4" |
|-----|-----------|------------------------|



Comment: Qty: 1.0400 Each(s)/Unit Total: 1.0400 Each(s)

Pick:

| | | | |
|-----|-------------|---------------------|---------------|
| Qty | Part Number | Description | Batch |
| 1 | D2500-1-190 | Skid Tube Extrusion | <i>B29602</i> |

Jb 7-3-19

| | | |
|-----|-------|---------|
| 3.0 | D2596 | 205 Web |
|-----|-------|---------|



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch |
| 1 | D2596 | 205 Web | <i>B29724</i> |

Jb 7-3-20

| | | |
|-----|----------------|-------------------------|
| 4.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

- 1- Inspect mat'l D2500-1-190 for damage
- 2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends
- 3-Acid etch and Alodine tube per QSI 005 4.1
- 4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

*Jb 7-3-19**Jb 7-3-20*

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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Date: Wednesday, 3/7/2007 3:49:01 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 31061A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch
A/R Sikaflex-291 *M 103497*Sikaflex expire date: *7-10-1*Start Time: *10:30* Date: *7-3-20*Fin Time: *2:00* Date: *7-3-28**567-3-20*

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL 7-3-28

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

Pm 07-03-29(1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-03-30

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2576-3 Step *B29486**BE 07-03-30*

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

B

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 31061A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

20

D2579

Spacers

B30220 BE 07-03-30

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

BE 07-03-30

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M103317

BE 07 03-30

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M103317

BE 07 03-30

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

Pm 07-04-04①

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

Pm 07-04-04①

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

Pm 07-04-04①

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

Pm 07-04-04①

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

Pm 07-04-04①

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/05

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/05

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

07-04-10①

07-04-10①

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 31061A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

POWDER COATING

POWDER COATING



m103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07/04/10 ①

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-h

07/04/10 ①

16.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D2577-1 | Wearplate | B29994 |

17.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D2577-3 | Wearplate | B29960 |

18.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D2577-5 | Wearplate | B30879 |

19.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|---------------|-------------|---------|
| 44 | ALS7-1032-130 | Inserts | M103495 |

X

HL

07-04-10 ①

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 31061A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 44 | AN960JD10L | Washer | M102832 |

21.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 44 | AN3-4A | Bolt | M100857 |

22.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

plug

Batch: B30140

23.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

o-ring

Batch: B27168

24.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B27188

25.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M15205

JD 0704-11 6

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/19

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 31061A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

26.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M102832

MS 07-04-11 (1)

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 M103497

✓ Sikaflex expire date: 07-10

✓ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

✓ 3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M103497

Sikaflex expire date: 07-10

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

M103707

MS-L 07/04/16 (1)

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location: _____

PPP Rev: _____

PPP B31061

07/04/11

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/19

Job Completion



07/04/18

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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NOTE: Date & initial all entries



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|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2580 | REV. C SHEET 1 OF 2 |
| DATE 98.08.26 | | TITLE 205 SKIDTUBE ASSEMBLY | SCALE NTS |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.02 | AS MANUFACTURED | |
| C | 98.08.26 | REDRAWN, INCLUDED DEO 9094/9097 | |

RELEASED
98/09/17 DS

| QTY | Part Number | Description |
|-----|---|-------------------|
| X | D2580-041 | SKIDTUBE ASSEMBLY |
| * | D2500-1 | EXTRUSION |
| 1 | D2596 | 205 WEB |
| 1 | D2575 | AFT CAP |
| 1 | D2576 - 3 | STEP |
| 20 | D2579 | CROSS BOLT SPACER |
| 16 | D2594-1 | PLUG |
| 16 | D2594-3 | O-RING |
| 1 | D2577-1 | WEARSHOE |
| 1 | D2577-3 | WEARSHOE |
| 1 | D2577-5 | WEARSHOE |
| 44 | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130 | INSERT |
| 46 | AN3-4A | BOLT |
| 46 | AN960JD10L | WASHER |

98.08.28
UP 00.08.28

EFFECTIVE DEOS
98/12/14
DEO 9124
DED 9183

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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NO. 31061A

Diagram illustrating the underside of a propeller with grinding locations marked. The diagram includes the following labels and features:

- GRIND FLUSH (4 PLACES)**: Points to four locations along the outer edge of the propeller.
- GRIND FLUSH**: Points to a specific grinding location on the left side.
- GRIND FLUSH**: Points to a specific grinding location on the right side.
- LOCATION RIDGE ON UNDERSIDE OF D2576**: Points to a ridge on the right side of the propeller.
- STEP**: Points to a step on the right side of the propeller.

UNCC
SUB

D2575 CAP

AN960JD10L WASHER (1)
(2 PLACES)

AN3-4A BOLT (1)

#0.208

DRILL PRIOR TO D2575 CAP
INSTALLATION (2 PLACES)

SEAL WITH
SIKAFLEX-241

Exploded view diagram of a wheel assembly. The diagram shows a circular wheel with a central hub. The components are labeled as follows:

- D2579 SPACER: Points to the central hub area.
- D2596 WEB (REF): Points to the main body of the wheel.
- ALS7-1032-130 (REF) (TYP 44 PLACES): Points to the four mounting points on the wheel's rim.

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 NO. 5

D2596
 ALS7-1032-3

37.50
DISTANCE TO AFT END
OF D2596 WEB
3 7
1.750 1.750
0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL A
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)

[illegible]

RELEASE
98/09/17 DS

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NO. 101

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number D205634041 / B31181 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

| | Position | Vertical | Down <input type="checkbox"/> | Up <input type="checkbox"/> |
|--------------|-----------------------------|-----------------------------|-------------------------------|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 3G <input type="checkbox"/> | 4G <input type="checkbox"/> |
| Tube Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 5G <input type="checkbox"/> | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 3F <input type="checkbox"/> | 4F <input type="checkbox"/> |
| Tube Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 4F <input type="checkbox"/> | 5F <input type="checkbox"/> |

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/03/29 Qualifier David Arwal

Date: Friday, 09/02/2007 9:59:35 AM
User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|--------------------------------|------------------|------------------------------|
| Customer | : CC-DAR01 Dart Aerospace Ltd. | Drawing Name | : D205-635 / D204-635 |
| Job Number | : 30722 | | |
| Estimate Number | : 10804 | | |
| P.O. Number | : N/A | Part Number | : Z-CUSTOM ECN952/908 |
| This Issue | : 09/02/2007 S.O. No. : N/A | Drawing Number | : UPDATE PAPERWORK |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : OVERHEAD | Drawing Revision | : N/A |
| Previous Run | : 00015 | Material | : N/A |
| Written By | : | Due Date | : 16/02/2007 Qty: 1 Um: Each |
| Checked & Approved By | : | | |
| Comment | : | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
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D205-634-011

D205-634-041

D205-634-043

D205-634-045

D204-635-011

D204-635-041

*voir papier
avec ✓*

7/4/27 SQ

| | | |
|-----|-------------|-----------------------|
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